



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2057
Job Sheet 182373



Part No: D2057

Job Qty: 20 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP Rev:E 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:F 08-06-04 Added QC8 JLM Verified By:EC IPP Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-1		JBD 18/10/18
100	Hardinge	20 pcs	9/7/18	9/7/18	0.00	1.17	Hardinge		" "
120	QC	20 pcs	9/7/18	9/7/18	0.00	0.00	QC8		Kt 2018-10-22
130	Packaging	20 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		OCT 22 2018
140	QC21-SA	20 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op 100 - Make as per Dwg D2057 and Folio FA260. Break all sharp edges 0.015 max. Do not drill Ø0.191
Descriptions: 130 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	2 ft (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.750	2	56	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	1.150Inches ± 0.030	1.180 1.120		
2	Plug	0.150Inches ± 0.030	0.180 0.120		
3	Plug	0.750Inches ± 0.030	0.780 0.720		
4	Plug	0.030Inches ± 0.030	0.060 0.000		
5	Plug	45.000Degrees ± 0.000	45.000 45.000	Angle	
6	Plug	0.397Inches + 0.005 - 0.000	0.402 0.397		
7	Plug	0.150Inches ± 0.030	0.180	Radius	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____		Step #: _____		MRB (QSI042) Approval																	
Description Work Order <i>Disposition</i> 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 892-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S119992 Part: D2057 Job No: 182373 Serial No/Batch: S119992 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/21/18																					